

# Work Order ID 56327

February 17, 2010 2:39:54 PM



Page 1

Item ID: D2341

Accept



Setup Start



Revision ID:

Stop



Item Name: Litter Lock Bracket

Start Date: 2/17/10 Start Qty: 20.00



Cust Item ID:

Required Date: 2/24/10 Req'd Qty: 20.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-2-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2341

Rev F

100

0.00



BAND SAW

Bandsaw

Memo

0.00

ref 10.2.21

Jeaspa Bandsaw

Cut blank 12.7 " long

3

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

ref 10.2.21

HAAS CNC vertical machine #1

1- Mill as per Folio FA801 Rev: AA & Dwg D2341 Rev: F 2-Deburr  
per dwg D2341

3

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

ref 10.2.22

3

Quality Control

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 56327

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Date:

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Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

SL 10/02/22

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

SL 10/02/22

X 3

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

SL 10/02/23

X 3

START TIME: 12:00pm FINISH TIME: 12:30pm OVEN TEMPERATURE: 320°F

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 56327

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Item Name: Litter Lock Bracket

Start Date: 2/17/10 Start Qty: 20.00



Cust Item ID:

Required Date: 2/24/10 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160



QC

Quality Control

~~QC~~ 100% Inspect kits for completeness  
*QC inspect powder coat.*  
Memo

0.00

0.00

*5.0/2/20*

*P127*

170



Packaging

Packaging

Identify as per dwg & Stock Location: 222

Memo

0.00

0.00

*P4/3/01 (3)*

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

*10/03/03*

*CL 03/01/10*

W/O: 56327		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/2/23	#160	Perm. change change step <del>to</del> to QC3 from QC4.	AA	10.03.03			S 10/02/23

Part No: D2341 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 56327



Parent Item: D2341



Parent Item Name: Litter Lock Bracket

Start Date: 2/17/10

Required Date: 2/24/10

Comments: IPP Rev:A New Issue 07-07-04 JLM

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6201		Manufactured	No			100	f	9.3432	23.1579			



"T" Extrusion



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

9.34315

9.34315

45500 ✓

3.175

10.2.21

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	56327
<b>Description:</b> Litter Tie Down Bracket (Locking)		<b>Part Number:</b>	D2341
<b>Inspection Dwg:</b> D2341	<b>Rev:</b> F	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.750	+/-0.010	1.750	/			
2.75	+/-0.030	2.750	/			
Ø0.242	+0.005/-0.001	.242	/			
Ø0.191	+0.005/-0.001	.192	/			
R0.25	+/-0.030	R. 250	/			
R0.40	+/-0.030	R. 400	/			
12.50	+/-0.030	12.500	/			
11.750	+/-0.010	11.750	/			
11.00	+/-0.030	11.000	/			
7.00	+/-0.030	7.000	/			
6.250	+/-0.010	6.250	/			
5.50	+/-0.030	5.500	/			
1.50	+/-0.030	1.500	/			
0.750	+/-0.010	.750	/			
0.400	+/-0.010	.400	/			
1.584	+/-0.010	1.584	/			
2.610	+/-0.010	2.610	/			
0.250	+/-0.010	.250	/			
0.844	+/-0.010	.845	/			
Ø0.250	+/-0.010	.250	/			
0.750	+/-0.010	.755	/			
3.313	+/-0.010	3.309	/			
4.250	+/-0.010	4.250	/			
1.250	+/-0.010	1.250	/			

<b>Measured by:</b> [Signature]	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 10.2.22	<b>Date:</b> 10/02/22	<b>Date:</b>	N/A

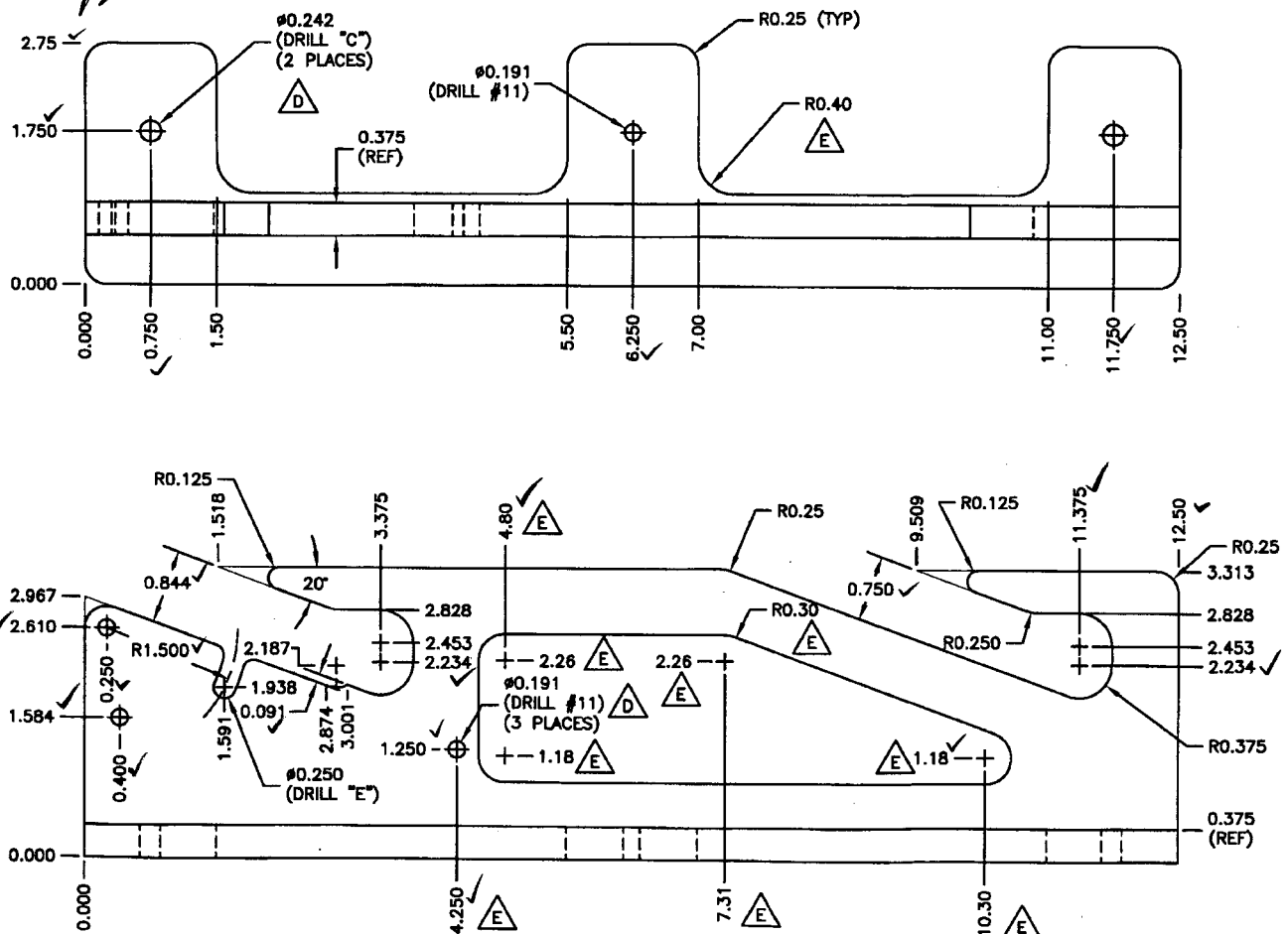
Rev	Date	Change	Revised by	Approved
A	06.05.24	New Issue P/O D2360	KJ/JLM	
B	07.07.17	Dwg Rev. updated	KJ/JLM	
C	10.02.02	Dimensions updated	KJ	[Signature]



**DART**

DESIGN BW	DRAWN BY JC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D2341	REV. F SHEET 1 OF 1
DATE 07.06.07		TITLE LITTER TIE DOWN BRACKET (LOCKING)	SCALE 1:2
A	95.01.13	NEW ISSUE	
B	95.02.14	MODIFIED LOCK	
D	95.02.20	CHANGES TO DIAMETERS	
E	97.10.01	CHANGES FOR MACHINING	
F	07.06.07	REVISED NOTES; FINISH WAS ANODIZE	

SHOP COPY  
RETURN TO  
ENGINEERING  
FOR ROLLED COPY  
OF AMENDMENT  
JUSTICE  
K DER  
56327  
N 10-21

**D2341 LITTER TIE DOWN BRACKET (LOCKING)**

- 1) MATERIAL: MAKE FROM D6201-0125 EXTRUSION  
(6061-T6/T651 PER QQ-A-200/B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3
- 3) BREAK ALL SHARP EDGES TO 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N "D2341" USING FINE POINT  
PERMANENT INK MARKER

**RELEASED**

07-06-22

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